

Work Order ID 122755

July-22-14 8:43:32 AM

122755

Page 1

Item ID: D3752-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Frame
 Start Date: 7/22/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/01/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-07-22 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3752	Rev C								
100		0.00							DAS 07 9-89
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Cut sheet to required size								14/08/13
105		0.00							DAS 07 9-89
105	Dry Material								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								14/08/13

Temp: 245 deg. F **AUG 13 2014**
 Time IN: 5:00 PM
 Time OUT: 6:00 AM Per.....

122755

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

4

4

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

122755

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/22/14 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 8/01/14 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

⑤ 14.08.22 DAS
9
989

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

14/8/20(4)

QC21- Final Inspection - Work Order Release

0.00

180

OC

Memo

0.00

Quality Control

MLJ 14-08-25

MLJ 14-08-25

Picklist Print

July-22-14 8:43:31 AM

Page 1

Work Order ID: 122755

122755

Parent Item: D3752-1

D3752-1

Parent Item Name: Seat Frame

Start Date: 7/22/14

Required Date: 8/01/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV: A New Issue 08.06.03 DL verified by:DD
IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C
Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105
Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	5,753.525	10.667	57			DAS 07 9-89

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	3193.525	
124866	106	
m126425	160.925	
m127934	699.6	
m128746	2227	
TPI	2560	
m129759	2560	

14/08/13

57.58 AL

DART AEROSPACE LTD		Work Order: 122755
Description: Seat Frame		Part Number: D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

DAS

Measured by: 07
9-89

Date: 14/08/13

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	0.040"	✓		ULTRA	
0.035	Min	0.056"	✓		ULTRA	
0.040	Min	0.060"	✓		VERA DL-02	
0.075	Min	0.107"	✓		ULTRA	
0.052	Min	0.082"	✓		ULTRA	
0.021	Min	0.032"	✓		ULTRA DL-02	
0.036	Min	0.063"	✓		ULTRA DL-02	

DAS

Measured by: 07
9-89

Date: 14/08/13

Audited by: DAS
9

Date:

Prototype Approval: 11-08-22
9-89

Date:

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

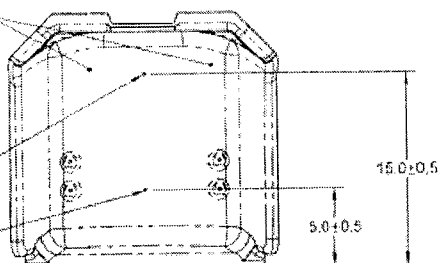
FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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ENSURE MATERIAL IN THIS AREA IS OPAQUE WITH A CONTINUOUS TEXTURE

OPTIONAL TOOLING HOLE. 0.028 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE. 0.035 MIN THICKNESS AT THIS LOCATION



0.040 MIN THICKNESS ALONG TOP EDGE

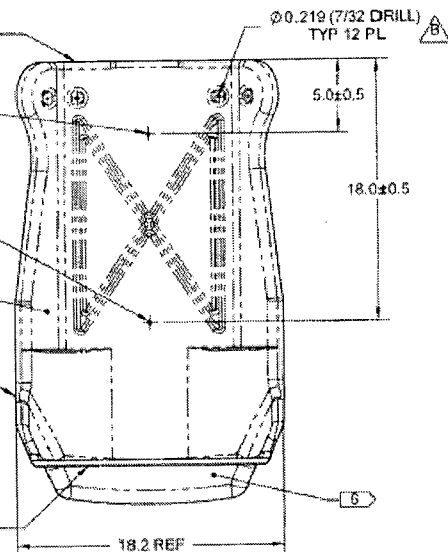
OPTIONAL TOOLING HOLE. 0.075 MIN THICKNESS AT THIS LOCATION

OPTIONAL TOOLING HOLE. 0.052 MIN THICKNESS AT THIS LOCATION

HEAVY HAIRCELL TEXTURE ON THIS SIDE

0.021 MIN THICKNESS IN THIS AREA (CORNER)

0.036 MIN THICKNESS ALONG BOTTOM EDGE



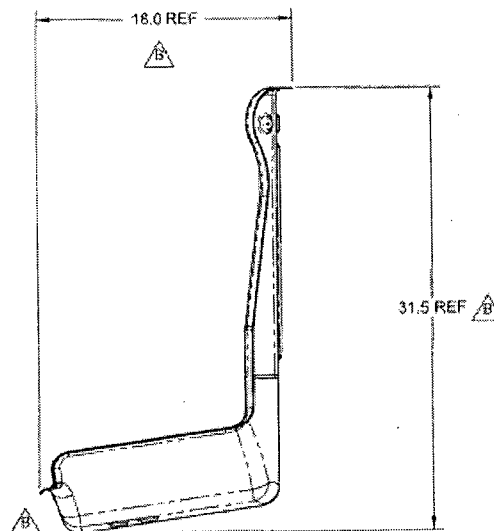
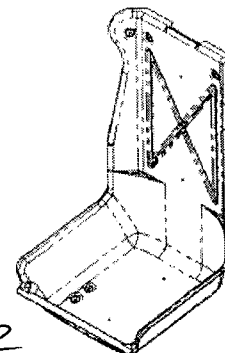
D3752-1 SEAT FRAME

NOTES:

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS. 125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N 'D3752-1' & B/N 'BXXXXX' USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122755MLJ

14-07-22



RELEASED
08/11/05

C	REDUCE THICKNESS: 0.040 WAS 0.050 (Z1 C8-1), 0.075 WAS 0.100 (C3-1), 0.052 WAS 0.090 (B8-1), 0.021 WAS 0.030 (B5-1), 0.036 WAS 0.050 (A5-1), 0.025 WAS 0.035 (D8-1), 0.035 WAS 0.050 (D5-1). SOME HOLES NOW OPTIONAL (A5-1 TO D5-1)	CP	08.10.08
B	FRONT PORTION NOW SHORTER (B5-1), 18.0 WAS 19.0 (C4-1), 31.5 WAS 30.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENT (D8-1, D8-1)	CP	08.09.08
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR			
DE APPR			
DATE	08.10.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3752** REV. C
SHEET 1 OF 1

TITLE **SEAT FRAME** SCALE NTS

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DQA: _____ Date: _____



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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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